

Work Order ID 55355

Page 1

January 13, 2010 2:45:49 PM

Item ID: D3947-1

Accept



Setup Start



Revision ID:

Item Name: Panel, Upper LH Post

Stop



Start Date: 1/13/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-1-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
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D3947	A	100	0.00						
		HAND FINISHING THERMOFORMING							
HandThermo			0.00						
Hand Finishing Thermoforming		Memo							
		Cut Blanks to fit frame size							

PL 10/01/13 (x1)

110		0.00							
		THERMOFORMING MACHINE							
Thermoform		Memo	0.00						
Thermoforming Machine		1-Machine Set-up							
		2-Pre-heat tool							
		3-Thermoform as per Dwg. D36476-1 and Folio FTA 044 using tool DT9483							
		Dwg. Rev. <u>A</u>							
		Folio Rev. <u>A</u>							

PL 10/01/13 (x1)

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Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

Visually inspect for proper formation of each part

D. 10/01/13 (X)

130



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

B 13/01/14 (X)

140



HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions as per dwg D3946-1

D. 10/01/14 (X)

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Required Date: 1/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/01/14 (X)

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

=> S1060116



170



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

(D-1-18) D SP

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberReject
NumberInsp.
Stamp

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/1998

MF
10-1-18

Picklist Print

Page 1

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Work Order ID: 55355



Parent Item: D3947-1



Parent Item Name: Panel, Upper LH Post

Start Date: 1/13/10

Required Date: 1/19/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MLEXS.093-F6006-07

Purchased

No

100

sf

749.8927

3.4795

GE PLASTICS LEXAN SHEET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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Location

Main Warehouse

MAT

749.8926526

107574

16.62

111973

190.526053

112176

542.7466

3.3054 sq ft

Wk 10/01/13 (1)

DART AEROSPACE LTD	Work Order:	55355
Description: Panel, Upper LH	Part Number:	D3947-1
Inspection Dwg: D3947 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:

GL

Date:

10/01/14

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.0	Min	10.0	✓			
0.2	Min	0.24	✓			
0.5	Min	0.57	✓			
1.8	Min	1.8	✓			
3.1	REF	3.125	✓			
26.6	REF	26.7	✓			
0.050	Min	0.064	✓			
0.070	Min	0.071	✓			

Measured by:

GL

Date:

10/01/14

Audited by:

BB

Date:

10/01/14

Prototype Approval:

N/A

Date:

N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<i>GL</i>







